(2) Bolts and studs must extend completely through the nuts.

(3) See § 58.30–15(c) of this chapter for exceptions on bolting used in fluid power and control systems.

(b) Carbon steel bolts or bolt studs may be used if expected normal operating pressure does not exceed 300 pounds per square inch gage and the expected normal operating temperature does not exceed 400 °F. Carbon steel bolts must have heavy hexagon heads in accordance with ANSI B18.2.1 and must have heavy semifinished hexagonal nuts in accordance with ANSI B18.2.2, unless the bolts are tightly fitted to the holes and flange stress calculations taking the bolt bending stresses into account are submitted. When class 250 cast iron flanges are used or when class 125 cast iron flanges are used with ring gaskets, the bolting material must be carbon steel conforming to ASTM Specification A 307 (incorporated by reference, see § 56.01–2), Grade B.

(c) Alloy steel stud bolts must be threaded full length or, if desired, may have reduced shanks of a diameter not less than that at the root of the threads. They must have heavy semifinished hexagonal nuts in accordance with ANSI B18.2.2.

(d) All alloy bolts or bolt studs and accompanying nuts are recommended to be threaded in accordance with ANSI B1.1, Class 2A external threads, and Class 2B internal threads (8-thread series 8UN for 1 inch and larger).

(e) (Reproduces 108.5.6.) Washers, when used under nuts, shall be of forged or rolled steel.

[CGFR 68–82, 33 FR 18843, Dec.18, 1968, as amended by CGD 77–140, 54 FR 40605, Oct. 2, 1989; USCG–2000–7790, 65 FR 58460, Sept. 29, 2000]

Subpart 56.30—Selection and Limitations of Piping Joints

§ 56.30–1 Scope (replaces 110 through 118).

(a) The selection and limitation of piping joints shall be as required by this subpart in lieu of requirements in 110 through 118 of ANSI-B31.1; however certain requirements are marked ''reproduced'' in this subpart.

[CGFR 68–82, 33 FR 18843, Dec. 18, 1968, as amended by CGFR 69–127, 35 FR 9978, June 17, 1970]

§ 56.30–3 Piping joints (reproduces 110).

The type of piping joint used shall be suitable for the design conditions and shall be selected with consideration of joint tightness, mechanical strength and the nature of the fluid handled.

§ 56.30–5 Welded joints.

(a) *General.* Welded joints may be used for materials for which welding procedures, welders, and welding machine operators have been qualified in accordance with part 57 of this subchapter.

(b) *Butt welds—general.* Butt welds may be made with or without backing or insert rings within the limitations established in § 56.70–15. When the use of backing rings will result in undesirable conditions such as severe stress concentrations, corrosion or erosion, then:

(1) The backing rings shall be removed and the inside of the joint ground smooth, or

(2) The joint shall be welded without backing rings, or

(3) Consumable insert rings must be used. Commonly used types of butt welding end preparations are shown in ANSI B16.25.

(4) Restrictions as to the use of backing rings appear for the low temperature piping systems and should be checked when designing for these systems.

(c) *Socket welds* (*Modifies 127.3.3A.*). (1) Socket welds must conform to ANSI B16.11, applicable standards listed in Table 56.60–1(b) of this part, and Figure 127.4.4C in ANSI B31.1 as modified by § 56.30–10(b)(4) of this part. A gap of approximately one-sixteenth inch between the end of the pipe and the bottom of the socket must be provided before welding. This may best be provided by bottoming the pipe and backing off slightly before tacking.

(2) Socket welds must not be used where severe erosion or crevice corrosion is expected to occur. Restrictions on the use of socket welds appear in

§56.70–15(d)(3) of this part for Class I service and in §56.50–105 of this part for low temperature service. These sections should be checked when designing for these systems. See §56.70–15(d)(4) of this part for Class II service.

(3) (*Reproduces 111.3.4.*) Drains and bypasses may be attached to a valve of fitting by socket welding provided the socket depth, bore diameter, and shoulder thickness conform to ANSI B16.11.

(d) *Fillet welds.* Fillet welds may vary from convex to concave. The size of a fillet weld is determined as shown in Figure 127.4.4A of ANSI B31.1. Fillet weld details for socket-welding components must meet §56.30–5(c) of this part. Fillet weld details for flanges must meet §56.30–10 of this part. See also §56.70–15(d)(3) and (d)(4) of this part for applications of fillet welds.

(e) *Seal welds.* Seal welds may be used but shall not be considered as contributing any strength to the joint.

[CGFR 68–82, 33 FR 18843, Dec. 18, 1968, as amended by CGFR 69–127, 35 FR 9978, June 17, 1970; CGD 77–140, 54 FR 40605, Oct. 2, 1989; CGD 95–012, 60 FR 48050, Sept. 18, 1995]

§56.30–10 Flanged joints (modifies 104.5.1(a)).

(a) Flanged or butt-welded joints are required for Classes I and I-L piping for nominal diameters exceeding 2 inches, except as otherwise specified in this subchapter.

(b) Flanges may be attached by any method shown in Figure 56.30–10(b) or by any additional means that may be approved by the Marine Safety Center. Pressure temperature ratings of the appropriate ANSI standard must not be exceeded.

(1) *Figure 56.30–10(b), Method 1.* Flanges with screw threads may be used in accordance with Table 56.30–20(c) of this part.

(2) *Figure 56.30–10(b), Method 2.* ANSI B16.5 class 150 and class 300 low-hubbed flanges with screw threads, plus the addition of a strength fillet weld of the size as shown, may be used in Class I systems not exceeding 750 °F or 4 NPS, in Class II systems without diameter limitations, and in Class II-L systems not exceeding 1 NPS. If 100 percent radiography is required by §56.95–10 of this part for the class, diameter, wall thickness, and material of pipe being joined, the use of the threaded flanges is not permitted and buttwelding flanges must be provided. For Class II piping systems, the size of the strength fillet may be limited to a maximum of 0.525 inch instead of 1.4T.

(3) *Figure 56.30–10(b), Method 3.* ANSI B16.5 slip-on flanges may be used in Class I, Class II, or Class II-L systems not to exceed the service pressure-temperature ratings for the class 300 and lower class flanges, within the temperature limitations of the material selected for use, and not to exceed 4 NPS in Class I and Class II-L systems. If 100 percent radiography is required by §56.95–10 of this part for the class, diameter, wall thickness, and material of the pipe being joined, the use of slip-on flanges is not permitted and a butt welding flange must be provided. The configuration in Figure 127.4.4B(b) of ANSI B31.1. utilizing a face and backweld may be preferable in those applications where it is desirable to eliminate void spaces. For Class II piping systems, the size of the strength fillet may be limited to a maximum of 0.525 inch instead of 1.4T and the distance from the face of the flange to the end of the pipe may be a maximum of three-eighths inch. Restrictions on the use of slip-on flanges appear in §56.50–105 of this part for low temperature piping systems.

(4) *Figure 56.30–10(b), Method 4.* ANSI B16.5 socket welding flanges may be used in Class I or II-L systems not exceeding 3 NPS for class 600 and lower class flanges and 2½ NPS for class 900 and class 1500 flanges within the service pressure-temperature ratings of the standard. Whenever full radiography is required by §56.95–10 for the class, diameter, and wall thickness of the pipe being joined, the use of socket welding flanges in not permitted and a butt weld type connection must be provided. For Class II piping, socket welding flanges may be used without diameter limitation, and the size of the fillet weld may be limited to a maximum of 0.525 inch instead of 1.4T. Restrictions on the use of socket welds appear in §56.50–105 for low temperature piping systems.

(5) *Figure 56.30–10(b), Method 5.* Flanges fabricated from steel plate meeting the requirements of part 54 of